

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015897**Date Inspected:** 18-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform Submerged Arc Welding (SAW) Welding on Longitudinal Diaphragm of OBG Segment 13BW, weld joint identified as LD3035-001-002. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044774 and 044795 perform Flux Core Arc Welding (FCAW) Welding on side plate stiffener of OBG Segment 13BE, weld joint identified as SP3074-001-010~018. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 044774 and 044795 perform FCAW Welding on side plate stiffener of OBG Segment 13BE, weld joint identified as SP3074-001-046 and 047. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 067183 perform SMAW Welding on corner assembly of OBG Segment 12BW, weld joint identified as CA3008-003. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 045133 perform SMAW Welding on corner assembly of OBG Segment 12BW, weld joint identified as CA3008-004. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

During the Quality Assurance (QA) random in-process visual inspection this QA inspector observed OBG segment 13 stiffeners are improperly stored at fabrication bay 14. Please see the attached pictures below.

OBG Segment 11DW

This QA inspector observed ZPMC qualified welding personnel identified as 045246 and 045868 perform SMAW Welding on OBG Segment 11DW, weld details are identified as X8E stiffener misalignment area. ZPMC QC is identified as Mr. Li Ping and Welding Repair Report is identified as B-WR13991. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair. See the attached picture.

OBG Segment 11EE

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 11EE, weld joint identified as SEG074A-010. ZPMC QC is identified as Mr. Li Ping and Welding Repair Report is identified as B-WR11257. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair.

OBG Segment 11BE

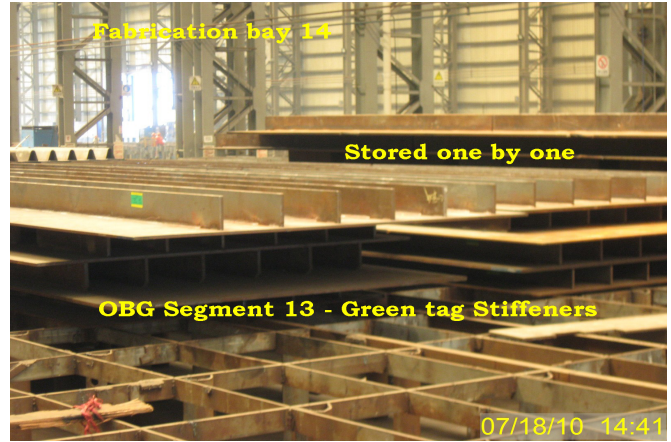
This QA inspector observed ZPMC qualified welding personnel identified as 044779 perform SMAW Welding on T-Stiffener of OBG Segment 11BE, weld joint identified as SP596-001-300 and 301. ZPMC QC is identified as Mr. Wang Xing Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112.

This QA inspector observed ZPMC qualified welding personnel identified as 044779 perform SMAW Welding on T-Stiffener of OBG Segment 11BE, weld joint identified as SP556-001-300 and 301. ZPMC QC is identified as Mr. Wang Xing Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer